

Work Order ID 81292

March-12-12 3:56:30 PM

81292

Page 1

Item ID: D3219-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 12/03/2012 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 26/03/2012 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3219	Rev A

100		0.00							
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100 FLOW WATER JET
 Waterjet Memo 0.00 B2-3-21

FLOW CNC Waterjet 1-Cut as per Dwg D3219
 Dwg Rev: A
 Prog Rev: A 

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110 QC Memo 0.00 B2-3-21

Quality Control

120	QC8- Inspect parts - second check	0.00							
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120 QC Memo 0.00 W 12-03-22 

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130	Small Fab	0.00							
Small Fab	Memo 1-Debur if necessary.	0.00							
140	QC5- Inspect part completeness to step on W/O	0.00							
140	QC	0.00							
Quality Control	Memo								
150	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
150	Packaging	0.00							
Packaging	Memo *** STOCK IN STEP CELL***								

12 03 22 (80)
 80 0

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 12/03/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 60.00

60

Customer:

Reference:

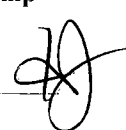
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21 - Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/4/10 

11204-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-12-12 3:56:34 PM

Work Order ID: 81292

81292

Parent Item: D3219-1

D3219-1

Parent Item Name: Plate

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A04.04.19New issueKJ/JLM
ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	92.5800	0.0964	6.088421	4.		

M6061T6S 125

**

1812-3-21

6061-T6 .125 Sheet

Location	Loc Qty	Loc Code
MAT021	92.58	
113608	46.69	
118217	0.09	
119513	10.8	
120218	35	

120218



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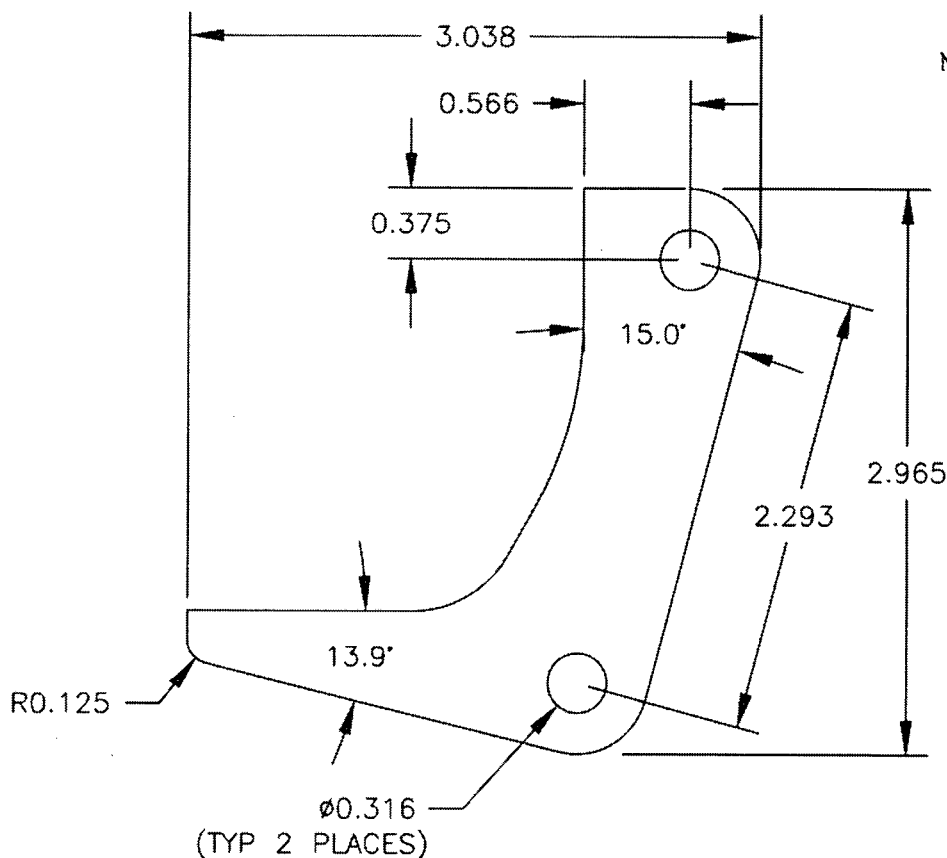


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 81292 *MLJ*
12/03/12



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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